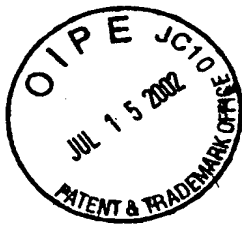




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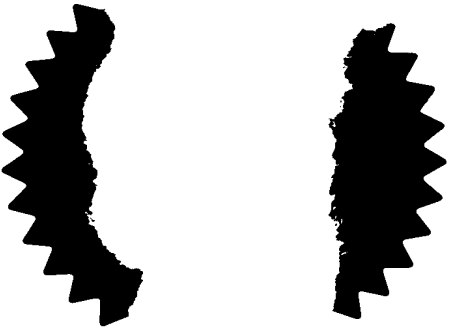
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1. Your reference **F3297(C)/pmk**

2. Patent applicant
(The Patent Office) **0125765.8** **26 OCT 2001**

3. Full name, address and postcode of the or of each applicant (underline all surnames)

Patents ADP number (if you know it)

If the applicant is a corporate body, give the country/state of its incorporation

UNILEVER PLC
UNILEVER HOUSE, BLACKFRIARS
LONDON, EC4P 4BQ

1628002
UNITED KINGDOM

4. Title of the invention **BLACK TEA MANUFACTURE**

5. Name of your agent (if you have one) **THACKER, Michael Anthony**

"Address for Service" in the United Kingdom to which all correspondence should be sent (including the postcode)

Patents ADP number (if you know it)

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COLWORTH HOUSE, SHARNBROOK
BEDFORD, MK44 1LQ

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Country Priority application number Date of filing
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7. If this application is divided or otherwise derived from an earlier UK application, give the number and the filing date of the earlier application


Number of earlier application Date of filing
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8. Is a statement of inventorship and of right to grant of a patent required in support of this request? (Answer 'Yes' if:
a) any applicant named in part 3 is not an inventor, or
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Sandra Jane EDWARDS, Authorised Signatory

12. Name and daytime telephone number of person to contact in the United Kingdom **Petra Kimber, Tel 01234 222893**

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BLACK TEA MANUFACTURE

5 The present invention relates to tea processing, or more specifically, a process for manufacturing a high quality larger leaf black tea.

10 **Background and prior art**

Leaf tea may be prepared as green leaf tea or black leaf tea. Generally, to prepare black leaf tea fresh green leaves of the plant *Camellia sinensis* are withered (subjected to mild drying),
15 comminuted, fermented (in which process enzymes in the tea leaf use atmospheric oxygen to oxidise various substrates to produce brown-coloured products) and then fired (to dry the tea leaves). Green leaf tea is not exposed to the fermentation process. Partial fermentation may be used to produce intermediate-type teas
20 known as "oolong" tea.

Conventional wisdom dictates that in black tea manufacture tea must be macerated in some way to liberate the fermentative enzymes and their substrates within the leaves. One can macerate tea in
25 many ways but broadly speaking there are two main mechanised methods for doing this.

The first, called "orthodox manufacture", involves rolling pre-weighed batches of heavily withered tea leaves prior to
30 fermenting, firing and drying steps. So called "orthodox tea" is typically characterised by leaf particles that are aesthetically pleasing to many (resemble dried leaves rather than "granules" of CTC tea - see below) but produce lighter liquors due to less extensive fermentation and poorer infusion from the larger
35 particles.

The second method is the most popular of a number of non-orthodox, continuous methods that involves using a machine resembling a mangle that cuts, tears and curls tea leaves. The original machine was invented by W. McKercher in 1930 and is commonly referred to as a CTC (cut-tear-curl) machine. The finely cut product is known generically as "CTC tea" and is characterised by a fast infusion rate and strong colour. This method tends to produce tea that is more consistent and uniform in quality and than the orthodox method but, as the CTC process tends to cause agglomeration of the tea material, it has the appearance of "granules" rather than leaf fragments.

Both orthodox and CTC rollers are often used in conjunction with a rotorvane machine, which is a type of extruder used to pre-condition (squeeze/shred) leaves prior to maceration. The rotorvane was invented as a form of continuous orthodox roller, but is rarely used as such today. Liquors generated from rotorvane teas are similar to orthodox in terms of liquor properties and infusion rates. These methods and their history and role in tea manufacture are described in "Tea: Cultivation to Consumption" edited by K. C. Willson and M. N. Clifford, Chapman & Hall, 1992.

Generally speaking consumer preference for either orthodox or CTC tea is a matter of national or regional culture. In many countries the visual appearance and texture of leaf tea are important indicators of quality, larger leaf particles being associated with higher quality. In Western markets tea is increasingly purchased in filter paper bags and the colour of the infused product tends to be more important.

Some consumers however want the best of both worlds; i.e. a leaf tea that looks and feels like orthodox processed tea but has the liquor characteristics of a fuller fermented CTC processed tea. There is no commercially available tea manufacturing equipment that can deliver such a leaf tea.

The present applicants have developed methods for manufacturing black leaf teas that resemble orthodox processed tea but infuse like CTC processed tea.

5

Our co-pending United Kingdom patent application GB 0010315.0 discloses a method that involves withering a first supply of freshly plucked tea leaves, macerating the withered leaves, allowing the macerated withered leaves to ferment to produce macerated dhool, withering a second supply of freshly plucked tea leaves, mixing the macerated dhool obtained from the first supply of leaves with the withered leaves obtained from the second supply of leaves, rolling the mixture, allowing the rolled mixture to ferment, and drying the fermented mixture to yield black leaf tea.

15

Russian patent specification SU 1678276 discloses a method for processing tea leaves into tea granules and tea concentrates. Tea leaves are withered to a residual moisture content of about 64 to 65%, then rolled and graded. The smaller graded fraction is fermented and dried. The large fraction is cut and rolled then graded again. The small tea grades are processed further to make tea granules and the large grades are used to make tea concentrates.

20

Russian patent specification SU 1034686 discloses a method for manufacturing black leaf tea with good quality in a shorter than usual time. Tea leaves are withered to a residual moisture content of 70% moisture then rolled and graded. Larger leaves are reduced in size. The tea is mixed and simultaneously aerated with atmospheric air at 45 m³/hour for 15 minutes after which it is dry.

30

Examples in the prior art involve changes to the traditional orthodox process, but the cited benefits are to alter yields of specific grades, to utilise unwanted grades in other processes (e.g. the manufacture of instant or concentrated teas) or to

35

reduce processing time. The leaf products of these prior art disclosures remain traditional orthodox teas, i.e. slow infusing, high flavour, low colour teas. The present innovations differs significantly from these by generating teas with orthodox appearance but that infuse quickly and give CTC-type liquors (more coloury).

The present inventors, through a deeper understanding of the fermentation and infusion processes of tea, have developed an alternative method for making fast-infusing larger leaf black tea. This method can utilise adapted tea manufacturing equipment (such as the rotorvane and CTC) or novel processing equipment, but requires a thorough understanding and control of raw material (green leaf) properties, and the interaction with the processing equipment.

Statement of the invention

In broad terms the present invention relates to a process for manufacturing black tea comprising the steps of withering and macerating tea leaves, allowing them to ferment, firing the leaves to arrest fermentation and then drying the leaves to yield black leaf tea, the process being characterised in that the tea leaves are withered to a moisture content of between 64% and 70% (preferably between 64% and 68%) before being macerated by the controlled application of both shear and compression forces sufficient to disrupt the majority of cells within the tea leaf, to introduce morphological changes in the tissue (cell separation leading to air spaces more typically seen in mature leaves) and to redistribute the cell contents, all of which leads to fermentation and infusion typical of CTC teas, whilst maintaining the appearance of orthodox tea leaves having an orthodox leaf size of T or above (preferably V or above)

Black leaf tea made in this way resembles orthodox processed leaf tea but infuses in freshly boiled water at a rate in excess of that of the equivalent mass of the same size grade tea that has undergone orthodox processing. The quality of the infusion is especially high.

In one example, using adapted commercial tea manufacturing equipment, freshly plucked tea leaves are withered to a target moisture content between 64 and 70% preferably 64 to 68%, passed through a high pressure rotorvane machine modified to deliver increased shear and compression. The rotovane may be modified by fitting it with reverse facing vanes. Similar equipment which is capable of delivering the required shear and compression forces may be used instead of the modified rotovane. The rotovane step may be followed by a further cutting, dicing or chopping step to further tailor the size and shape of the particles. The further cutting step may take place by a single pass through a CTC machine modified so that its roller has fewer teeth per inch (tpi) than a conventional CTC machine. For example, the roller of the modified CTC machine preferably has 2 to 6 teeth per inch rather than the conventional 8 to 10 teeth per inch. This enables the modified CTC machine to reduce the size of very long leaves and stalk without producing the agglomerated finely cut leaf pieces that typify conventional CTC processed tea. As an alternative to the use of the modified CTC machine other dicing or chopping machines that give the required characteristics to the black tea may be used.

"Tea" for the purposes of the present invention means leaf material from *Camellia sinensis* or *Camellia assamica*. It also includes rooibos tea obtained from *Aspalathus linearis* however that is a poor source of endogenous fermenting enzymes. "Tea" is also intended to include the product of blending two or more of any of these teas.

"Leaf tea" means tea that contains one or more tea origins in an uninfused form.

"Black leaf tea" means substantially fermented leaf tea.

5

"Orthodox leaf size" means the leaf size of orthodox leaf tea that corresponds to the standard manufacturers' grades for pekoe. These are listed in Table 1.

- 10 For the avoidance of doubt the word 'comprises' is intended to mean including but not necessarily "consisting of" or "composed of". In other words the listed steps or options need not be exhaustive.

15 Brief description of the drawings

Figure 1 is a diagrammatic representation of the process of the present invention.

- 20 Figure 2 is a DCPR frequency histogram of large leaf black manufactured by the process described in co-pending United Kingdom patent application GB 0010315.0. See Example 4.

- 25 Figure 3 is a DCPR frequency histogram of large leaf black manufactured by the process of the present invention using a high pressure rotorvane without a subsequent 6 tpi CTC cut. See Ex. 4.

- 30 Figure 4 is a DCPR frequency histogram of large leaf black manufactured by the process of the present invention using a high pressure rotorvane with a subsequent 6 tpi CTC cut. See Ex. 4.

- 35 Figure 5 is a graph from which one can compare the infusion performance of certain orthodox and CTC teas with that of teas made according to the process described in our United Kingdom patent application GB 0010315.0 and the process of the present invention. See Example 5.

Figure 6 is a graph from which one can compare the quality and colour of milk-free infusions prepared from certain orthodox and CTC teas with that of teas made according to the process described in our United Kingdom patent application GB 0010315.0 and the process of the present invention. See Example 6.

Figure 7 is a graph from which one can compare the quality and colour of milked infusions prepared from certain orthodox and CTC teas with that of teas made according to the process described in our United Kingdom patent application GB 0010315.0 and the process of the present invention. See Example 7.

Figure 8 is a graph comparing the infusion performance of long leaf black teas made according to the process described in our United Kingdom patent application GB 0010315.0 and the process of the present invention. See Example 8.

Figure 9 is a graph comparing the infusion performance of medium leaf black teas made according to the process described in our United Kingdom patent application GB 0010315.0 and the process of the present invention. See Example 8.

Figure 10 is a graph showing the theaflavin levels obtained during the fermentation of tea leaves in the process of the present invention. See Example 10

Figure 11 is a graph showing the colour of infusions made from leaf tea prepared by the process of the present invention and from tea leaves made by other processes See Example 10

Figure 12 shows the structure of tea leaves made by the process of the present invention when examined by a microscope. See Example 10

Figure 13 is a graph showing the yields obtained by making modifications to the process of the present invention. See Example 11

5 Figure 14 is a graph showing the bulk densities of the teas obtained by making modifications to the process of the present invention. See Example 11

10 Figure 15 is a graph showing the colour of infusions of leaf tea obtained by making modifications to the process of the present invention. See Example 11

Detailed description of the invention

15

The process of the present invention combines steps normally associated with CTC manufacture with those normally associated with orthodox manufacture and/or those normally associated with non-tea related food processing in a way that provides high
20 quality fast-infusing large leaf tea within a predetermined grade profile.

A preferred scheme of the process of the present invention is shown in Figure 1. The steps shown in boxes drawn from dotted
25 lines represent an optional enhancement.

In the process a supply of freshly plucked tea leaves (so called green leaf) is withered prior to being macerated. The leaves can be withered in any conventional manner, for example by storing
30 them for a period of time, usually perhaps up to 16 to 24 hours, during which time they undergo various biochemical and physical changes and typically lose moisture. The leaves must be withered to have a specific leaf moisture content between 64 and 70% preferably between 64 and 68%. This degree of wither is less than
35 that used in conventional orthodox tea manufacture (where final moisture content is usually less than 60%, often near 50%). It is

also more than that used in conventional CTC tea manufacture, where the degree of wither has to be greater than 68%

(final moisture content usually near 70 - 78%) otherwise too much heat is generated in the CTC machinery, especially at commercial throughputs. This controlled withering is important not only for flavour generation (as conventionally accepted) but also to ensure optimal CTC-like fermentation (where higher moisture content leads to improved oxidation of polyphenols), and to alter the physical properties of the leaf to optimise their interaction with the maceration equipment, and enable the necessary commercial throughputs.

The withered leaf is then subjected to a controlled shearing and compressing action by some suitable means that gives a leaf tea that corresponds to an orthodox leaf size of at grade T or larger. The present inventors have found that subjecting the leaf to specific shearing and compressing forces during maceration results in effective internal disruption (both loss of integrity of the majority of individual cells within the tea leaf, and also the introduction of morphological changes in the tissue - cell separation leading to air spaces more typically seen in mature leaves) and to the redistribution of the cell contents, all of which leads to fermentation and infusion typical of CTC teas, whilst maintaining the appearance of orthodox tea leaves. The loss of integrity of the individual cells enables the mixing of the polyphenol substrates and the key oxidative enzyme polyphenol oxidase, a prerequisite for fermentation. Fermentation also requires oxygen, and the introduction of air spaces in the tissue helps overcome oxygen limitation observed in larger leaf pieces. In addition the present process allows this cell and tissue disruption to occur at a moisture content more optimal for fermentation than conventional orthodox manufacture. The introduced air spaces are preserved in the fired tea, which leads to more rapid hydration and infusion during the brewing process.

Operation of processing equipment to deliver the necessary shear and compression forces is dependant on the nature of the equipment, and its power supply. The important criteria are the effects on the tea leaves during maceration. This is judged by visual assessment of the dhool (juice being expressed on to the surface but not excessive loss of juice out of the dhool), analysis of the dhool (structure) and also of the made tea (infusion characteristics). For any specific piece of equipment operational parameters can be set once the above is achieved. For example a standard 15" rotorvane equipped with reverse-facing vanes as described in the current process is operated with a set throughput (e.g. 1500 kg \ hr) and iris setting to generate a current of 35 +\ - 5 amps. Similarly the gap setting of a 8.5" 6tpi CTC is set to achieve a current of 28 +\ - 3 amps.

The size of leaf tea is commonly measured in the tea trade at it is a critical factor in assessing the consumer acceptance and quality of tea. A system of grading leaf size has become standard amongst manufacturers. These grades are given in Table 1 below.

TABLE 1
Leaf size classification

CTC leaf size	Manufacturers' grades	ORTH leaf size	Manufacturers' grades
A	D2/CD	O	CD/ D3
B	D1	P	D
C	D	Q	PD/ SF
D	PD	R	BOPF/ PF
E	SMALL FNGS/PF/ PF1	S	FNGS/ FNGS2
F	PF1	T	BOP/ LEAFY POBF/ BT
G	LEAFY FNGS/ SMALL BP	U	LEAFY BOP/ SMALL PEKOE/ FBOP
H	BP1/ BOP	V	PEKOE
I	BOLP BP	W	LARGE PEKOE/ BPS
J	BM	X	OP
K	BMF	Y	BP/ BP2
		Z	BT2/ BM

The black leaf tea of the present invention is orthodox in shape with leaf size of grade T or higher (preferably Grade V or higher. Grades T, V and U are especially preferred when the leaf tea is to be packaged into tea bags.

The shearing and compressing action may be achieved using a high pressure rotorvane machine. A rotovane machine comprises an outer cylindrical jacket housing a central conveying rotor fitted with opposed vanes with every successive pair of vanes set at right angles to its neighbour. The outer jacket has inwardly facing ribs against which the tea leaves are pressed as they pass through the machine. The discharge end of the rotovane machine is fitted with an adjustable cone or iris which restricts the outlet providing control of the pressure within the machine. In a preferred high pressure rotovane for use in the process of the present invention at least some of the vanes of the rotovane are replaced with reverse facing vanes. Alternatively, similar equipment capable of delivering the required shearing and compression forces may be used instead of a high pressure rotovane (e.g. various extruder and roller designs are possible). This step may be followed by a further cutting, dicing or chopping step to give tea of the required size and shape. Preferably a modified CTC machine in which the roller has fewer teeth per inch than conventional CTC machines is used. The roller of the modified CTC machine preferably has 2 to 6 teeth per inch rather than the conventional 8 to 10 teeth per inch. This enables the modified CTC machine to reduce the size of very long leaves and stalk without producing the finely cut leaf pieces that typify conventional CTC processed tea. In addition during conventional CTC manufacture these finely cut leaf particles are agglomerated as a result of the repeated cutting, leading to the granular appearance of fired CTC tea. Alternatively a dicing or chopping machine capable of delivering the required size and/or shape profile can be employed following the high pressure rotovane. The present inventors have found that dicing machines, particularly

food dicing machines such as the J9-A model two dimensional belt-fed dicer with circular knives and the COMITROL™ food processors with rotary micro-cut heads that are commercially available from Urschel Laboratories Incorporated, Valparaiso, Indiana, USA are particularly suitable for this purpose.

The macerated leaves are then left to ferment. The term "fermentation" is commonly used in the context of brewing alcohol to describe the action of exogenous enzymes. However in the tea world it is used to refer to the oxidative process that tea undergoes when certain endogenous enzymes and substrates are brought together following the disruption of the cell walls and tissues. During this process colourless catechins in the leaves are converted to a complex mixture of yellow and orange to dark-brown substances and a large number of aromatic-volatile compounds are also produced. Fermentation can be carried out in a tub fermenter if desired.

The present inventors have found that the macerated leaf should be left to ferment for at least more than one hour, preferably more than two hours but preferably not more than 3 hours. A fermentation time of about 140 minutes is especially preferred. Leaving the leaves to ferment for longer than three hours can detrimentally effect the quality of the final product. It can also have cost implications. These times are dependent on the ambient temperatures, but are comparable to conventional times for fermentation of CTC tea.

Fermentation is preferably conducted at ambient temperature, i.e. about 25 °C, although 18 °C or even 15 °C can be suitable. If desired, fermentation can be accelerated at slightly higher temperatures such as 30 °C. The use of an oxygen-enriched atmosphere in a fermentation vessel is also beneficial.

The mass of fermented leaf macerate is known as known as dhool.

If desired, one can initiate fermentation in the withered leaves by subjecting the leaves to a heat shock at a temperature and for a duration that is sufficient to initiate fermentation as described in our international patent application WO 99/40799.

5

Alternatively, one can impregnate the withered tea leaves with liquid carbon dioxide within a pressure vessel, depressurise the vessel at a rate that is sufficient to freeze the liquid carbon dioxide, apply sufficient heat to cause the frozen carbon dioxide to sublime and consequently initiate fermentation within the leaves, allow the tea to ferment for a time that is sufficient to achieve desired liquor properties, and dry the fermented product to yield the whole leaf tea. Such a method is described in our international patent application WO 00/10401. A further alternative method of disrupting the leaves and initiating fermentation of rolled leaves is to subject the leaves to cycles of freezing and thawing.

If desired, the dhool can be treated with tannase (flavanol gallate esterase) to generate degallated catechins and gallic acid (which subsequently leads to the generation of high levels of theaflavins and non-gallated thearubigins during fermentation) or treated with tannase followed by hydrogen peroxide in a quantity that is sufficient for the endogenous peroxidases to oxidise gallic acid liberated by the tannase treatment. These treatments generate coloured species and enhance flavour. They are described in detail in our international patent application WO 00/47057, the disclosure of which is incorporated herein by reference.

If desired the grade profile can be further manipulated through the inclusion in the process of a dhool sifting step (see Figure 1). Such an operation fractionates the macerated leaf particles on the basis of size, by passing the dhool over a vibrating mesh. The mesh size is selected according to the desired change required in the final grade profile. Material passing through the mesh proceeds directly to fermentation, whilst the material retained by

the mesh is subjected to a further cutting operation. The latter can be achieved through using for example a rotorvane, a CTC or a cutting \ dicing machine such as those manufactured by Urschel. Once cut this material is also fermented. The sifting step can
5 occur immediately post the primary maceration, or preferably after a short fermentation (15 - 30 minutes) which reduces the "stickiness" of the dhool particles.

As a final step, the fermented mixture is fired, dried and sorted
10 to yield a black leaf tea that resembles orthodox processed leaf tea but infuses in freshly boiled water at a rate in excess of that of the equivalent mass of the same tea that has undergone orthodox processing.

15 The firing involves heating and drying the tea to destroy the fermenting enzymes and thereby arrest fermentation. It results in a reduction of moisture content to below 5%, preferably 2.5-3%, and also leads to further chemical/biochemical oxidation and changes in tea aroma. This generally involves exposing the tea to
20 a blast of hot, dry air in a dryer, for example a fluid bed dryer.

The present inventors, and expert tea tasters, were very surprised at the quality of the product produced by the process of the invention. Not only does it have the appearance of orthodox leaf,
25 and the fast infusion and red liquors associated with CTC teas, but it also has a very high overall quality and flavour. The process thus effectively delivers the most useful attributes from both CTC and orthodox teas, in one product.

30 The process of the present invention involves less process complexity than the method described in GB 0010315.0 and gives a product with greater flavour (and therefore higher quality as judged by international tea tasters). There is also more flexibility to alter leaf shape and/or size.

Large leaf tea can be difficult to dose when making tea bags. While one could simply remove the largest leaves using a sieving system and perhaps recycle them in the process it is clearly preferable to be able to manufacture the desired product with the
5 maximal yield and quality.

Orthodox appearance

10 An expert tea taster can clearly distinguish teas that have the appearance of orthodox and teas that have the appearance of CTC processed tea. In layman's terms, orthodox tea tends to be flattened, rolled and twisted and CTC processed tea is more granular in appearance. While tea tasting (which includes
15 grading) can appear to be more of an art than a science, the skilful precision with which experienced tea tasters can judge and categorise teas should not be underestimated.

In Example 2 an expert tea taster assessed black leaf tea made by
20 the process of the present invention as being orthodox tea.

Orthodox appearance as determined by particle shape

25 The flattening, rolling and twisting operations that typify orthodox black tea manufacture tend to produce slivers of leaf fragments whereas the more disruptive chopping action of CTC machines produces granular tea fragments that are more uniform in size and shape. One can therefore characterise teas that have an
30 orthodox appearance as having an average length that is preferably at least twice the average width of the tea (i.e. an aspect ratio of 2:1), more preferably at least three times the average width of the tea (i.e. aspect ratio 3:1).

35 In an extension to this, as an attempt to define orthodox appearance the applicant has devised a method for effectively

measuring the roundness of tea fragments, or rather their deviation from perfect roundness (see Examples 3 and 4). The method involves making images of tea fragments and measuring the D-circle perimeter ratio (DCPR). The DCPR is defined by the expression:

$$\text{DCPR} = \frac{P}{2\sqrt{A\pi}}$$

wherein P is the observed perimeter of a particle and A is its observed area. It is in effect the ratio between the actual perimeter of an object and the perimeter of its D-circle - i.e. a hypothetical circle that has the same area as the object. This parameter has a minimum value of DCPR = 1 (for a circle). All other shapes have DCPR values greater than one. It is independent of size.

The aspect ratio versus DCPR based on perfect rectangles can be compared as follows: 1:1 (1.128), 2:2 (1.197), 3:1 (1.303), 4:1 (1.410), 5:1 (1.514), 6:1 (1.612), 7:1 (1.706), 8:1 (1.795), 9:1 (1.881) and 10:1 (1.962). Of course in practice the irregular edges of real tea particles would increase the DCPR slightly. A black leaf tea of the present invention is one where preferably at least about 5% of the tea particles have a D-circle perimeter ratio of 1.6 or greater, more preferably at least about 10% of the tea particles have a D-circle perimeter ratio of 1.6 or greater, and even more preferably at least about 15% of the tea particles have a D-circle perimeter ratio of 1.6 or greater. This corresponds to an aspect ratio, for the relevant percentages, approaching 6:1.

Modification of appearance by cutting after rotorvane

Quartile analysis (see Example 4) reveals that exposing the leaves to higher pressure during maceration (as in the high pressure rotorvane) can lead to a higher percentage of longer leaf

particles, particularly in the large size fractions. Whilst this may be advantageous in some instances production of more uniform particles is necessary for many uses, particularly packing in to tea bags.

5

Treating the leaf with a cutting step (such as the 6 tpi CTC) post-rotorvane can modify the appearance in a positive manner. The product still resembles orthodox leaf, but is now more uniform in shape (i.e. "squarer"). Yield of "tea-bag compatible" grades increases from about 35 to 40% without the 6 tpi CTC machine to 55 to 60% with it.

10

CTC infusion character as determined by infusion performance

15

Black leaf tea made by the process of the present invention resembles orthodox processed black tea, at least on a macroscopic level, but it does not exhibit the infusion characteristics of orthodox processed tea. The product of the process of the present invention exhibits infusion characteristics normally only in seen in CTC processed teas. These characteristics include the rate and extent of infusion as evidenced by the amount of colour generated within a fixed time.

20

Infusion performance is determined in part by leaf particle size. Small leaves or leaf portions have a larger surface to volume ratio than large leaves or leaf portions and thus will tend to infuse faster than large leaves. The applicant has shown in Example 5 that when using comparable leaf sizes infusions of orthodox teas tend to be less red and more yellow than infusions of CTC teas and teas made by the process of the present invention infuse more like a CTC leaf tea than an orthodox leaf tea.

30

Ideally the black leaf tea of the present invention preferably infuses at a rate that is at least as fast as the equivalent mass of the same tea or one of a comparable size that has undergone CTC

35

processing. The black leaf tea can be blended with traditionally processed black tea or tea granules in order to meet predetermined liquor characteristics.

- 5 The infusion kinetics of the tea of the present invention have been compared to those of the United Kingdom patent application GB 0010315.0, and it can be clearly seen that for the two grades shown (large and medium leaf), the present leaf infuses faster and delivers a darker liquor. The co-pending application describes a
10 process manufacturing orthodox leaf with CTC infusion, that involves co-rolling freshly withered leaf and fermented CTC dhool. The present invention delivers a product with similar or improved infusion characteristics from a logistically less complex process (i.e. not requiring separate process lines for CTC dhool and
15 leaf).

CTC infusion character as determined by liquor quality

- 20 CTC infusion character can be determined by an expert tea taster, both in the presence or absence of milk, both qualitatively and quantitatively on a suitable industry scale. Tea experts can rate liquor quality (i.e. measuring taste attributes including flavour volatiles), colour, brightness and thickness using a scale such as
25 that used in Examples 6 and 7.

- The black leaf teas of the present invention infused in the absence of milk (as is common in Continental Europe and USA) or with milk added (as is common in the United Kingdom) provide a
30 liquor quality that resembles that of CTC manufactured teas rather than orthodox manufactured teas. The distinction was found to be more sharp when assessing the milked infusions. In fact the milked infusions of the black leaf teas of the present invention have been found to be as well coloured as the more colourful CTC
35 infusions.

One might even define the black teas of the present invention as those which when infused in tap water (Crawley, United Kingdom) for 2 minutes and 15 seconds at a concentration of 13.3 g/l then milked by adding 10 ml milk per 235 ml infusion the liquor quality is between from 4 to 6, but preferably between from 5 to 6.

The sensory properties of the tea of the present invention have been compared to those of the United Kingdom patent application GB 0010315.0, through Sensory Analysis (QDA). This reveals significant differences in the aromas of the two products, with higher aroma scores given for the tea of the current invention (contributing to the high quality as judged by the expert tea tasters).

The black leaf tea that is manufactured by the process of the present invention can be blended with traditionally processed black tea or tea granules in order to meet predetermined liquor characteristics.

The process of the invention will now be described with reference to the following illustrative examples.

EXAMPLE 1

Manufacture of black tea

The process of the current invention was operated at factory scale by Brooke Bond Kenya. Standard quality green leaf was withered for 16 hours to a final moisture content of 68+/-1%. The withered leaf was passed through a Vikram 15" rotorvane fitted with 3 reverse facing vanes, at a throughput of 1500kg/hour. The configuration of the rotorvane was adjusted to maintain a current of 35+/-5 amps (to deliver the necessary pressure). The dhool from the rotovane was fed directly into an 8.5" CTC machine fitted with 6 teeth per inch rollers. The gap width between the rollers was adjusted to maintain a current of 28+/-3 amps. The dhool from the CTC machine was loaded into GWA fermentation tubs, which were

connected to a humidified air supply. The flow of air through the dhool was adjusted to maintain a fermentation temperature of $22\pm 2^{\circ}\text{C}$, for a period of 150 ± 10 minutes. The tea was fired in a fluid bed dryer, maintaining an air outlet temperature of $180\pm 5^{\circ}\text{C}$, to a final moisture content of 2.5-3.0%. The sortation method was the same as that used in standard CTC manufacture. The mesh sizes on the Boulton sortation equipment were selected according to the particle size ranges required in the finished grades. Assessment of the product from this process is described in Examples 2 to 8.

EXAMPLE 2

Differentiating between the appearance of orthodox and CTC teas using an expert tea taster

15

The inventors asked an expert tea taster to select 17 teas from around the world, some orthodox and some CTC. They then asked the expert to classify those teas as well as two samples of each of two grades of black leaf teas that were made by the method of Example 1 (one medium leaf (ML), the other long leaf (LL)) as being either orthodox or CTC teas. The results are given in Table 2 below.

20

TABLE 2

Comparison of known and novel teas by an expert tea taster

Code	Type	Origin	Size	Leaf
ODX1	Orthodox	Indonesia	BOPF	OT5
ODX2	Orthodox	China	BOP	OT3
ODX3	Orthodox	Assam	FBOP	OU5
ODX4	Orthodox	Ceylon	EBOP	OU8
ODX5	Orthodox	Ceylon	BOP	OT5
ODX6	Orthodox	Indonesia	BOP	OT6
ODX7	Orthodox	Ceylon	BOP	OT5
CTC1	CTC	Siongo	BP1	CH6
CTC2	CTC	Ecuador	BP1	CH3
CTC3	CTC	Kavuzi	BP1	CH4
CTC4	CTC	Indonesia	BP1	CH3
CTC5	CTC	Vietnam	BOP	CI3
CTC6	CTC	Malawi	BP1	CI4
CTC7	CTC	Kenya Rukuriri	BP1	CH7
CTC8	CTC	Kenya Bondet	BP1	CH4
CTC9	CTC	Ceylon	BP1	CH4
CTC10	CTC	Assam	BP	CH5
280ML	-	Kenya, Kericho	ML	OT5
281ML	-	Kenya, Kericho	ML	OT5
280LL	-	Kenya, Kericho	LL	OV5
281LL	-	Kenya, Kericho	LL	OV5

10

Wherein the first letter of the three-letter code denotes whether the leaf tea has the appearance of leaf tea made by orthodox manufacture (O), CTC manufacture (C), or a mixture (M).

The second letter denotes the leaf size in accordance with standard manufacturers' grades as described in Table 3 below:

15

5

TABLE 3
Leaf size classification

CTC leaf size	Manufacturers' grades	ORTH leaf size	Manufacturers' grades
A	D2/CD	O	CD/ D3
B	D1	P	D
C	D	Q	PD/ SF
D	PD	R	BOPF/ PF
E	SMALL FNGS/PF/ PF1	S	FNGS/ FNGS2
F	PF1	T	BOP/ LEAFY POBF/ BT
G	LEAFY FNGS/ SMALL BP	U	LEAFY BOP/ SMALL PEKOE/ FBOP
H	BP1/ BOP	V	PEKOE
I	BOLP BP	W	LARGE PEKOE/ BPS
J	BM	X	OP
K	BMF	Y	BP/ BP2
		Z	BT2/ BM

And the third letter denotes the leaf style in accordance with the
10 rating system given in Table 4 below:

15

TABLE 4
Leaf style classification

Style	Leaf description
1	Powdery
2	Very stalky/fibrous
3	stalky/fibrous
4	Mixed/few fibres
5	Rather mixed
6	Fair
7	Good
8	Very good
9	Speciality/excellent style

The assessment was made on the basis of a number of factors
including leaf size, twist, surface area and colour. In each case
the tea taster classified the black teas of the invention as
20 having an orthodox appearance.

EXAMPLE 3**D-circle perimeter ratio analysis**

5

As mentioned above, the flattening, rolling and twisting operations that typify orthodox black tea manufacture tend to produce slivers of leaf fragments tea whereas the more disruptive chopping action of CTC machines and the tendency of the CTC process to cause agglomeration produces granular tea fragments. The applicant has devised a method for effectively measuring the roundness of tea fragments, or rather their deviation from perfect roundness.

10

15

The method involves making images of tea fragments and measuring the D-circle perimeter ratio (DCPR). The DCPR is defined by the expression:

20

$$\text{DCPR} = \frac{P}{2 \cdot \sqrt{A \cdot \pi}}$$

25

wherein P is the observed perimeter of a particle and A is its observed area. It is in effect the ratio between the actual perimeter of an object and the perimeter of its D-circle - i.e. a hypothetical circle that has the same area as the object.

30

This parameter has a minimum value of DCPR = 1 (for a circle). All other shapes have DCPR values greater than one. It is independent of size.

35

Samples of some of the teas from around the world used in Example 2 were taken and compared with samples of medium long leafed (ML) teas and long leafed teas (LL) prepared by the process of Example 1. In each case small samples were taken randomly with a spatula.

Only the outline shape of the particles (i.e. silhouettes) of the particles needed to be imaged, not the surface detail. It was also important that shadows be avoided. The leaf samples were therefore spread out on a sheet of glass and back-illuminated on a
5 WILD M8™ low power microscope. A magnification was chosen which allowed as many particles as possible per field, but at the same time allowed each particle to be sufficiently large for meaningful measurements to be taken. The magnification chosen gave a field size of 21 x 15.75 mm.

10

Images were grabbed using a JVC KY 55™ camera and a NOETECH™ frame grabber. The pixel resolution was 768 x 576. Some background was left visible in each micrograph in order to ensure that the particles had not been eroded by over-lighting. Twelve or fifteen
15 fields were taken for each sample, giving a total particle count of typically 300 - 400. All images were permanently archived.

20

An image analyser (KONTRON KS 300™) was used to measure binary images (i.e. where all pixels are either black or white). The areas to be measured are rendered white, the background is black. 'Segmentation' is the process by which the binary image is generated from the original.

25

The original image was rendered monochrome. A threshold level was selected below which everything was rendered black (pixel value = 0) and above which everything was rendered white (i.e. pixel value = 255). The threshold level varied slightly from image to image, and was chosen to avoid either dilating or eroding the outline of the particles; it was generally around 140. This produced an
30 image in which the particles were black and the background white.

35

The image was reversed (i.e. to produce white particles on a black background) and any particles in contact with the edge of the image (and therefore partly obscured) were deleted. The end result at this stage was a binary segmentation mask. These were also archived.

Prior to measurement, each image was put through an 'opening' procedure that alternately eroded and dilated particles three times. This had the effect of smoothing the surfaces slightly and removing small surface decorations which do not contribute to the overall shape or size of the object, but which can inflate an estimate of its perimeter. This part of the procedure was performed in the aforementioned KONTRON KS 300™ imager analyser.

Particles were then measured and the data aggregated from all the images in each sample set. The results obtained are given in Table 5 below.

TABLE 5

Comparison of known and novel teas by measuring frequency of particles having certain D-circle perimeter ratios

SAMPLE	% DCPR < 1.2	% DCPR 1.2-1.39	% DCPR 1.4-1.59	% DCPR ≥ 1.6
ctc1	12.5	68.0	16.7	2.9
ctc3	25.0	61.9	9.5	3.7
ctc6	20.3	65.6	9.7	4.4
ctc8	12.4	66.0	19.5	2.1
ctc10	19.7	66.3	12.2	1.8
odx1	8.1	53.4	24.3	14.3
odx2	21.5	56.2	13.6	8.7
odx3	4.3	34.2	36.2	25.3
odx4	3.2	33.7	33.0	30.2
odx5	12.6	48.8	28.0	10.6
odx7	11.4	40.5	29.6	18.5
odx7	11.4	40.5	29.6	18.5
280ML	4.3	41.3	32.5	21.9
280LL	4.2	34.8	37.0	24.0

CTC teas show a much higher proportion of particles in the <1.2 DCPR class (10 - 25%) than in the ≥ 1.6 class (3 - 4%); i.e. they consisted in the main of low aspect ratio material. The orthodox teas were more variable. ODX2 was much like a CTC in character, whereas ODX3 & ODX4 showed only 3 - 4% in the <1.20 DCPR class but 25% & 30% in the ≥ 1.6 class. But in general known orthodox

manufactured teas contain significantly more particles having a DCPR greater or equal to 1.6 than known CTC manufactured teas.

The black leaf teas prepared by the method of the present invention were shown to have a higher percentage of particles, particularly in the larger size fractions, having a DCPR greater or equal to 1.6 thus confirming their orthodox appearance.

EXAMPLE 4

10 Modification of appearance by cutting after rotorvane

DCPR analysis was also performed on novel large leaf manufactured (a) using the process described in co-pending United Kingdom patent application GB 0010315.0 (see Table 6 and Figure 2), (b) 15 using the high pressure rotorvane as described in Example 1 but without the subsequent 6 tpi CTC cut (see Table 7 and Figure 3) and (c) using the high pressure rotorvane as described above with a subsequent 6 tpi CTC cut as described in Example 1 (see Table 8 and Figure 4). The results represented as frequency histograms in 20 Figures 2, 3 and 4.

TABLE 6

25 Quartile analysis of large leaf tea made by the process described in GB 0010315.0

DCPR	Frequency %								
	0.00- 0.99	1.00- 1.19	1.20- 1.39	1.40- 1.59	1.60- 1.79	1.80- 1.99	2.00- 2.19	2.20- 2.39	2.40- 2.59
Quartile 1	0	14.09	50.34	18.79	10.74	2.68	2.01	0.67	0
Quartile 2	0	11.84	53.95	22.37	9.21	0.66	1.32	0.66	0
Quartile 3	0	3.31	49.67	30.46	11.26	3.31	1.32	0.66	0
Quartile 4	0	3.27	33.33	37.25	13.07	9.15	3.27	0.65	0

TABLE 7

Quartile analysis of large leaf tea made by the process of the present invention without a subsequent 6 tpi CTC cut

DCPR	Frequency %								
	0.00- 0.99	1.00- 1.19	1.20- 1.39	1.40- 1.59	1.60- 1.79	1.80- 1.99	2.00- 2.19	2.20- 2.39	2.40- 2.59
Quartile 1	0	4.42	44.25	28.32	16.81	5.31	0.88	0	0
Quartile 2	0	0	40.71	26.55	14.16	9.73	3.54	5.31	0
Quartile 3	0	0	23.89	32.74	25.66	12.39	2.65	2.65	0
Quartile 4	0	1.79	15.18	35.71	18.75	11.61	10.71	2.68	3.57

5

TABLE 8

Quartile analysis of large leaf tea made by the process of the present invention with a subsequent 6 tpi CTC cut

DCPR	Frequency %								
	0.00- 0.99	1.00- 1.19	1.20- 1.39	1.40- 1.59	1.60- 1.79	1.80- 1.99	2.00- 2.19	2.20- 2.39	2.40- 2.59
Quartile 1	0	6.72	41.79	27.61	15.67	4.48	2.99	0.75	0
Quartile 2	0	5.88	45.59	35.29	8.09	5.15	0	0	0
Quartile 3	0	5.19	48.15	21.48	14.81	8.15	2.22	0	0
Quartile 4	0	2.19	28.47	41.61	17.52	8.03	1.46	0	0

10

It was concluded from these results that exposing the leaves to higher pressure during maceration (as in the high pressure rotorvane) can lead to a higher percentage of longer leaf particles, particularly in the large size fractions.

15

Treating the leaf with a cutting step (such as the 6 tpi CTC) post-rotorvane can modify the appearance such that while the product still resembles orthodox leaf it is more uniform in shape (i.e. "squarer"). However the yield of "tea-bag compatible" grades increases from about 35 to 40% without the 6 tpi CTC machine to 55 to 60% with it.

20

EXAMPLE 5

Differentiating between the infusion performance of orthodox and
CTC teas by infusion performance

25

Orthodox manufactured teas generally infuse more slowly than CTC manufactured teas. This reflects the degree of maceration. One would therefore expect a black leaf tea that resembles orthodox tea to infuse like an orthodox tea.

5

The inventors selected 13 of the teas from around the world used in Example 2 and compared the infusion performance of those teas against teas made by the process described in our co-pending United Kingdom patent application GB 0010315.0 (143 ML and 147 ML) and the process of Example 1 (269 ML and 270 ML). The teas were selected purely on the basis of comparable leaf sizes. This was necessary since small leaves have a larger surface to volume ratio than large leaves and thus will tend to infuse faster than large leaves anyway.

15

In each case 200 ml boiling deionised water was added to a pre-warmed Thermos flask containing 2 g (± 0.05 g) leaf tea. The flask was stoppered and briefly inverted, then the leaf was allowed to infuse for 3 minutes. The flask was then inverted again, and the liquor filtered through WHATMAN 541™ filter paper, using a Buchner funnel and flask under vacuum.

The colour of the infusions was measured on a HUNTERLAB ULTRASCAN Xe™ colorimeter using a standard analytical method (provided by the manufacturer). The results quoted in Table 9 below are for a 1 cm path length, with D65 illuminant and an observer angle of 10°.

Colour is measured and represented by three colour dimensions, L*, a* and b*. L* represents paleness/darkness, with L = 0 being black and L = 100 being white or colourless. a* represents redness/greeness, with high positive values of a* being red and high negative values of a* being green. B* represents blueness/yellowness, with high positive values of b* being yellow and high negative values of b* being blue.

TABLE 9
Infusion performance of leaf teas of comparable size

SAMPLE	L*	a*	b*
ODX01	83.1	8.5	69.7
ODX02	81.9	8.3	61.2
ODX05	82.2	11.2	79.9
ODX06	82.5	9.3	74.2
ODX07	79.1	11.9	72.5
CTC01	80.8	12.8	82.8
CTC02	79.7	13.5	80.7
CTC03	77.9	19.1	91.9
CTC04	80.4	12.5	80.4
CTC07	77.3	12.0	75.3
CTC08	75.4	14.7	80.4
CTC09	74.3	17.5	85.3
CTC10	74.3	18.7	91.2
143 ML	80.45	14.12	82.92
147 ML	78.55	16.9	86.95
269 ML	79.47	16.28	91.50
270 ML	80.72	14.56	89.09

5

The a* and b* values were plotted to give Figure 5. Each point on the graph plots the position of the liquor colour in colour space. Points nearer the top right hand corner of the graph represent
 10 liquors with stronger yellow or red components respectively.

One can see from Figure 5 that the leaf teas of the present invention (269ML and 270ML) fall within the cluster of results for CTC teas rather than the cluster of results of the orthodox teas.
 15 This clearly demonstrates that the black leaf teas of the present invention infuse like CTC manufactured teas rather than orthodox manufactured teas.

20

EXAMPLE 6**Differentiating between the infusion performance of orthodox and CTC teas by infusion performance in the absence of milk**

5 The inventors infused each of the 17 teas from around the world used in Example 2 and compared the infusion performance of those teas against teas made by the process described in our co-pending United Kingdom patent application GB 0010315.0 (143,146,147,149, 152 LL and 143,146,147,149,152 ML) and the process of Example 10 1 (280,281 ML and 280,281 LL).

In each case, to imitate the preparation of tea in Continental Europe, 2.0 g (± 0.05 g) tea was infused in 250 ml of freshly boiled tap water (Crawley, United Kingdom) for 1.5 minutes and an expert tea taster assessed the liquor quality with respect to 15 quality (Q), colour (C), brightness (B) and thickness (T).

Liquor quality was measured on a scale of from 0.6 to 9.4 as given in Table 10 below.

20

TABLE 10**Liquor quality assessment**

Q - Quality	0.6 (plain)	9.4 (flavoury)
C - Colour	0.6 (yellow)	9.4 (red)
B - Brightness	0.6 (dull)	9.4 (bright)
T - Thickness	0.6 (thin)	9.4 (thick)

25 The results are given in Table 11 below.

30

TABLE 11
Liquor quality assessment of non-milked infusions

SAMPLE	Q	C	B	T
ODX1	4.0	3.0	4.2	3.0
ODX2	2.6	2.6	2.8	2.6
ODX3	4.4	2.2	4.0	4.0
ODX4	4.0	4.4	4.4	4.6
ODX5	5.2	2.2	5.4	3.0
ODX6	4.6	2.0	5.6	2.6
ODX7	4.4	3.0	5.2	4.0
CTC1	5.0	4.0	6.0	3.6
CTC2	3.0	4.2	5.0	3.4
CTC3	4.0	4.2	5.0	2.2
CTC4	3.4	4.6	5.0	3.0
CTC5	2.8	4.4	4.6	3.6
CTC6	2.6	3.2	4.0	3.0
CTC7	5.6	2.0	6.0	2.8
CTC8	4.6	4.6	5.8	4.6
CTC9	3.6	4.4	5.6	4.0
CTC10	4.8	4.0	5.8	5.0
143 LL	5.0	3.8	5.2	4.0
146 LL	4.6	4.2	5.2	4.2
147 LL	5.2	4.0	5.4	4.0
149 LL	5.0	4.2	5.2	4.2
152 LL	5.4	3.6	5.4	4.0
143 ML	4.8	4.4	5.2	4.4
146 ML	4.4	4.8	5.4	4.6
147 ML	4.6	4.4	5.4	4.4
149 ML	4.8	4.4	5.4	4.4
152 ML	5.0	4.0	5.4	4.0
280 LL	5.0	4.0	5.0	4.2
281 LL	5.2	4.0	5.0	4.0
280 ML	5.0	4.4	5.0	4.4
281 ML	5.2	4.4	5.0	4.6

5

The Q (quality) and C (colour) values were plotted to give Figure 6. One can see from that Figure that the known CTC manufactured teas tended to provide more colourful infusions than the known orthodox manufactured teas. It is also clear from Figure 6 that black teas of the present invention infused in a manner akin to more colourful CTC manufactured teas rather than orthodox manufactured teas.

10

EXAMPLE 7**Differentiating between the infusion performance of orthodox and CTC teas by infusion performance in the presence of milk**

5

The inventors infused each of the 17 teas from around the world used in Example 2 and compared the infusion performance of those teas against teas made by the process described in our co-pending United Kingdom patent application GB 0010315.0 (143,146,147,149, 10 152 LL and 143,146,147,149,152 ML) and the process of Example 1 (280,281 ML and 280,281 LL).

In each case, to imitate the preparation of tea in the United Kingdom, 3.125 g (± 0.05 g) tea was infused in 235 ml of freshly 15 boiled tap water (Crawley, UK) for two minutes 15 seconds (static brew). The liquor was then tipped onto 10ml of semi-skimmed milk and an expert tea taster assessed the liquor quality with respect to quality (Q), colour (C), brightness (B) and thickness (T). Liquor quality was measured on a scale of from 0.6 to 9.4 as given 20 in Table 10 above. The results are given in Table 12 below.

25

30

35

5

TABLE 12
Liquor quality assessment of milked infusions

SAMPLE	Q	C	B	T
ODX1	4.2	3.2	4.4	3.6
ODX2	2.4	2.0	2.0	2.6
ODX3	4.2	2.6	4.6	3.8
ODX4	3.8	2.8	4.0	4.6
ODX5	5.6	3.6	5.8	3.2
ODX6	4.4	3.2	5.4	3.0
ODX7	4.0	2.8	4.6	4.0
CTC1	4.6	4.0	6.0	3.6
CTC2	2.8	4.2	4.4	3.0
CTC3	3.8	6.6	4.2	2.2
CTC4	3.2	5.0	4.0	2.8
CTC5	2.8	4.2	4.4	3.8
CTC6	3.0	5.8	4.0	3.0
CTC7	5.6	4.0	6.4	3.0
CTC8	3.6	7.2	3.6	4.2
CTC9	4.0	4.0	5.0	4.0
CTC10	4.6	4.0	6.0	4.6
143 LL	4.6	5.6	4.0	4.0
146 LL	4.2	5.6	4.2	4.0
147 LL	5.0	5.2	4.8	4.2
149 LL	4.6	5.4	4.4	4.0
152 LL	5.2	5.0	5.0	4.2
143 ML	4.4	5.8	4.0	4.4
146 ML	4.2	6.0	4.0	4.4
147 ML	4.6	5.6	4.4	4.4
149 ML	4.4	5.8	4.2	4.6
152 ML	5.0	5.0	5.0	4.2
280 LL	4.8	4.4	5	4.4
281 LL	5.2	4.6	5	4.4
280 ML	5	4.8	5.2	4.6
281 ML	5.2	4.8	5.2	4.8

10 The Q (quality) and C (colour) values were plotted to give Figure 7. One can see from that Figure that all of the known CTC manufactured teas provided more colourful milked infusions than all of the known orthodox manufactured teas. It is also clear

from Figure 7 that black teas of the present invention provided milked infusions amongst the best of the known CTC manufactured teas.

5

EXAMPLE 8

Comparing infusion performance of black leaf teas made by the process of GB 0010315.0 and the process of the present invention

10

2g of long leafed and medium leafed black teas made by the process of our co-pending United Kingdom patent application GB 0010315.0 and 2 g samples of two batches of black leaf teas made by the process of Example 1 from the same tea leaves were infused in 200-ml boiling water and the rate of infusion was tracked by measuring absorbance at 445 nm. The measurements for the long leafed teas are plotted in Figure 8 and the measurements for the medium leafed teas are plotted in Figure 9.

20 It is clear from both Figures that black teas made by the process of the present invention infused significantly faster and more completely than the tea made by the process of our co-pending United Kingdom patent application GB 0010315.0.

25

EXAMPLE 9

The following black teas were prepared in a Brooke Bond Kenya tea factory, (a) standard CTC tea (b) tea produced with a standard rotorvane, (c) tea produced by the process of the present invention using a high pressure rotorvane and (d) teas produced by the process of the present invention using a high pressure rotorvane followed by 6tpi CTC. The teas produced were assessed by an expert tea taster in a similar way to that described earlier in Example 6 and the scores are given in Table 13.

Table 13

SAMPLE	Q	C	B	T
CTC	4.8	3.4	5.6	3.8
Standard rotovane	5.6	3.0	5.8	3.8
High pressure rotovane	5.0	3.5	5.4	3.7
High pressure rotovane and 6tpi CTC	5.1	3.7	5.4	4.0

5 It can be seen that the use of the high pressure rotorvane to
apply the necessary shear and compression in the process of the
present invention results in higher colour scores. In addition to
altering the grade profile the use of the 6 tpi CTC after the high
pressure rotovane step leads to even higher colour scores.

10

EXAMPLE 10

In order to optimise the current process, and to understand it
better, a programme of work was carried out at a pilot-scale in
15 the UK (Colworth Research Laboratory). This work compared a
process according to the present invention in which the tea leaves
were macerated by high pressure rolling followed by a low pressure
cut with a conventional CTC process and a process in which the tea
leaves were macerated by a low pressure cut only (this does not
20 form part of the present invention). The impact of a high
pressure treatment of tea leaf during maceration was demonstrated
during such pilot-scale processing experiments.

Green leaf (Kenyan Clone 35) obtained as a chilled shipment from
25 Brooke Bond Kenya plantations was withered to a moisture content
of 68 +/- 1%, and was either macerated with a low pressure cut
using a Alexanderwerk AWBS 150 Vegetable Slicer or subjected to a
high pressure roll with a Twin Roll Mill (RSG Colworth), operating
at speed ratio of 4:1, gap width 150µm followed by the low
30 pressure cut. After maceration the dhool was fermented for 120
minutes at 25°C and subsequently dried in a lab-scale fluid-bed
drier. Analysis of theaflavin levels (Figure 10) during

fermentation clearly show the enhanced fermentation in material subjected to the rolling step. This is also reflected in the colour measurements taken from the liquors of made tea samples (Figure 11). Small, medium and large grades were analysed and in all cases the rolled samples gave more coloury liquors. The effect was however more pronounced as the particle size increased. Microscopic examination of the macerated leaf reveal that the rolling step introduces a significant number of air spaces in to the tissue (Figure 12), which are retained in the made tea. These air spaces allow faster hydration and infusion of the tea particles during the brewing process.

EXAMPLE 11

A comparison was made between using a 6tpi CTC to modify the leaf post-rotorvane as described in the process of Example 1 and using an Urshel Comitrol (model 3600). This was performed at pilot-plant scale in a Brooke Bond Kenya tea factory. Green leaf was withered in troughs to a moisture content of 68-70% and fed into an 8" rotorvane at 200Kg/hr. Dhool from the rotorvane was passed through either the CTC or the Comitrol with one of three different heads (with varying aperture size, 3.0mm, 4.0mm or 5.00mm). Post-maceration dhool was fermented on two Continuous Fermenting Units (CFU 1, 60 minutes, temperature 20-22°C; CFU 2, 80 minutes, temperature 24-26°C) and subsequently dried in a fluid-bed drier and sorted to give large (LL), medium (ML) and small (SL) grades. These grades produced using the Comitrol machine were compared with tea produced using the 6tpi CTC machine as described in Example 1. Figure 13 shows the yields obtained using the above procedures. Figure 14 shows the bulk densities of the dried black teas produced by the above procedures. Figure 15 indicates the colour of the infusions as represented by the "a*" value (ie the "redness" of the infusion measured as described in Example 5) for infusions made from the teas produced by the above methods. The Comitrol can be used in place of the 6tpi, with the advantage of higher bulk density (advantages for packing, particularly in to tea-bags) and the ability to manipulate grade profile through the selection of different heads.

CLAIMS

- 5 1. A process for manufacturing larger leaf black tea comprising
the steps of withering and macerating tea leaves, allowing them
to ferment, firing the leaves to arrest fermentation and then
drying them to yield black leaf tea,
- 10 the process being characterised in that the tea leaves are
withered to a moisture content of between 64% and 70% before
being macerated by the controlled application of both shear and
compression forces sufficient to disrupt the majority of cells
15 within the tea leaf, to introduce morphological changes in the
tissue and to redistribute the cell contents, all of which
leads to fermentation and infusion typical of CTC teas, whilst
maintaining the appearance of orthodox tea having an orthodox
leaf size of T or above .
- 20 2. A process according to claim 1 wherein the tea leaves are
withered to a moisture content of between 64 and 68%
3. A process as claimed in claim 1 or claim 2 wherein the tea
leaves are macerated to give orthodox leaf size V, U or T.
- 25 4. A process according to claim 3 wherein the tea leaves are
macerated to give orthodox leaf size V.
5. A process according to any preceding claim wherein the withered
30 tea leaves are macerated by being passed through a rotorvane
machine.
6. A process according to any preceding claim wherein the withered
leaves are macerated by being passed through a rotorvane
35 machine in which at least some of the vanes have been replaced
by reverse facing vanes.
7. A process according to claim 5 or claim 6 wherein the tea
leaves leaving the rotovane are further cut, diced or chopped.

8. A process according to claim 7 wherein the tea leaves leaving the rotovane are further cut by being passed through a CTC machine.

5

9. A process according to claim 8 wherein the blade of the CTC machine has 2 to 6 teeth per inch.

10

10. A process according to claim 7 wherein the tea leaves leaving the rotovane are further diced or chopped by being passed through a two dimensional belt-fed dicer with circular knives or a food processor with rotary micro-cut heads

15

11. A process according to claim 1 wherein the withered leaves are macerated by being passed through an extruder machine.

20

12. A black leaf tea having an orthodox appearance and an orthodox leaf size of T or above obtainable by a process that comprises the steps of withering tea leaves to a moisture content of between 64% and 70%, macerating the leaves by the controlled application of both shear and compression forces sufficient to disrupt the majority of cells within the tea leaf, to introduce morphological changes in the tissue and to redistribute the cell contents, all of which leads to fermentation and infusion typical of CTC teas, whilst maintaining the appearance of orthodox tea

25

30

13. A black leaf tea having the appearance of orthodox leaf tea and an orthodox leaf size of T or greater which when infused in boiling water for 3 minutes at a concentration of 10g/l provides an infusion that has an a* value of at least 14 and a b* value of at least 88

35

ABSTRACTBlack tea manufacture

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A process for manufacturing a fast infusing larger leaf black tea. The process involves withering tea leaves to a moisture content between 64 and 70%, macerating the withered leaves tea leaves by the controlled application of both shear and compression forces
10 sufficient to disrupt the majority of cells within the tea leaf, to introduce morphological changes in the tissue and to redistribute the cell contents, all of which leads to fermentation and infusion typical of CTC teas, whilst maintaining the appearance of orthodox tea having an orthodox leaf size of T or
15 above



Figure 1

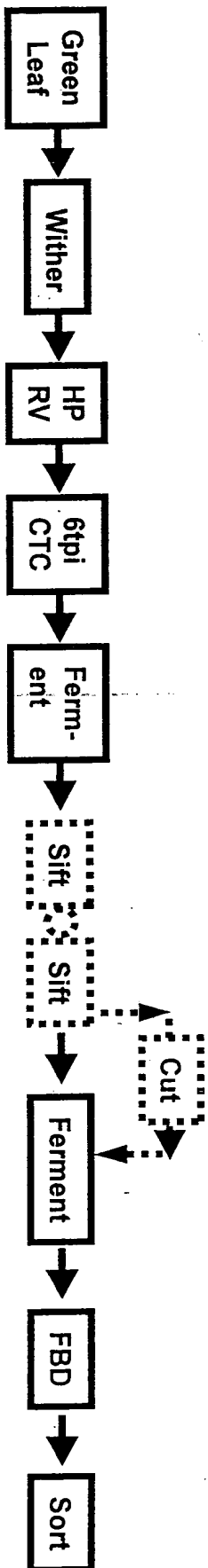




Figure 2

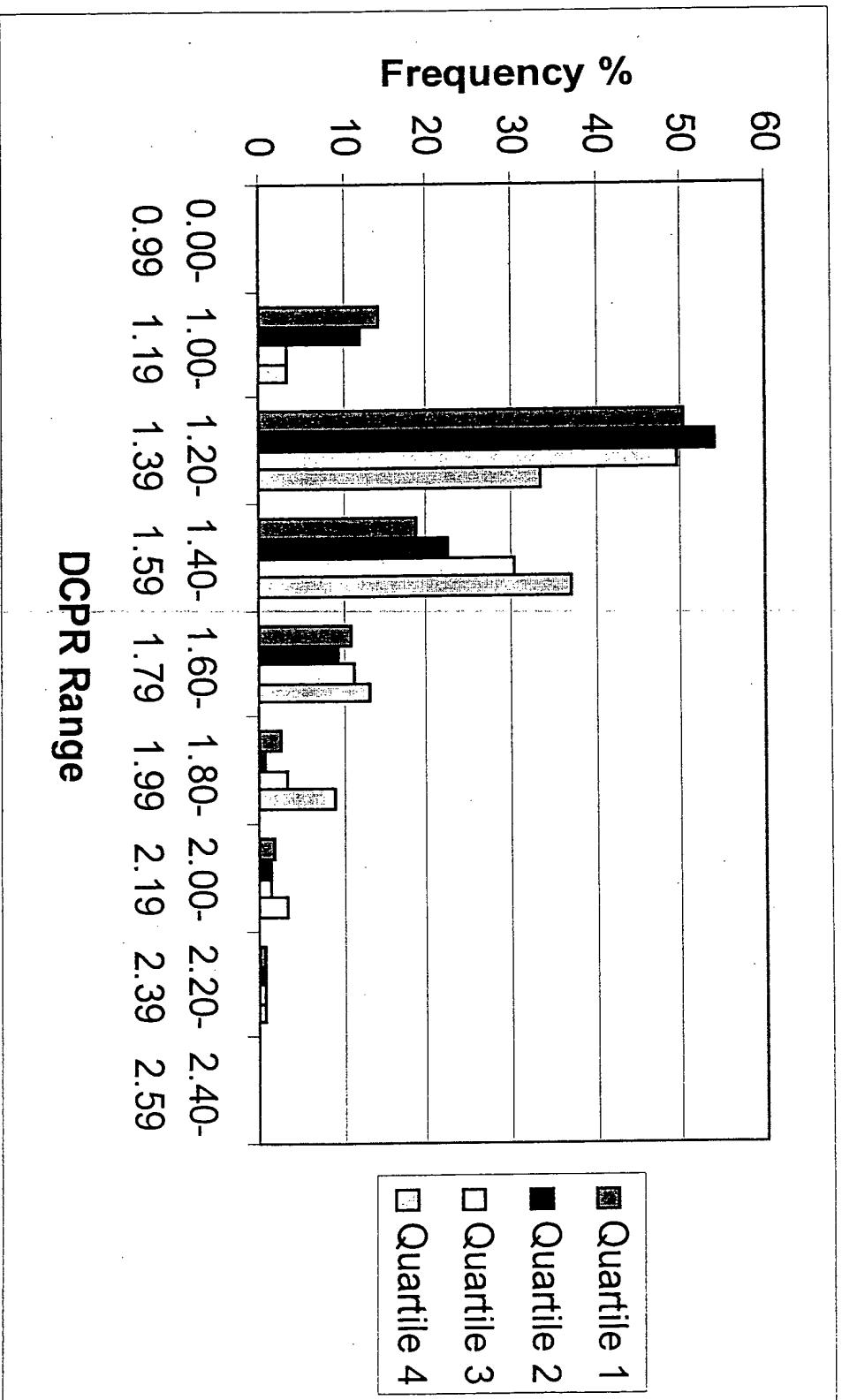




Figure 3

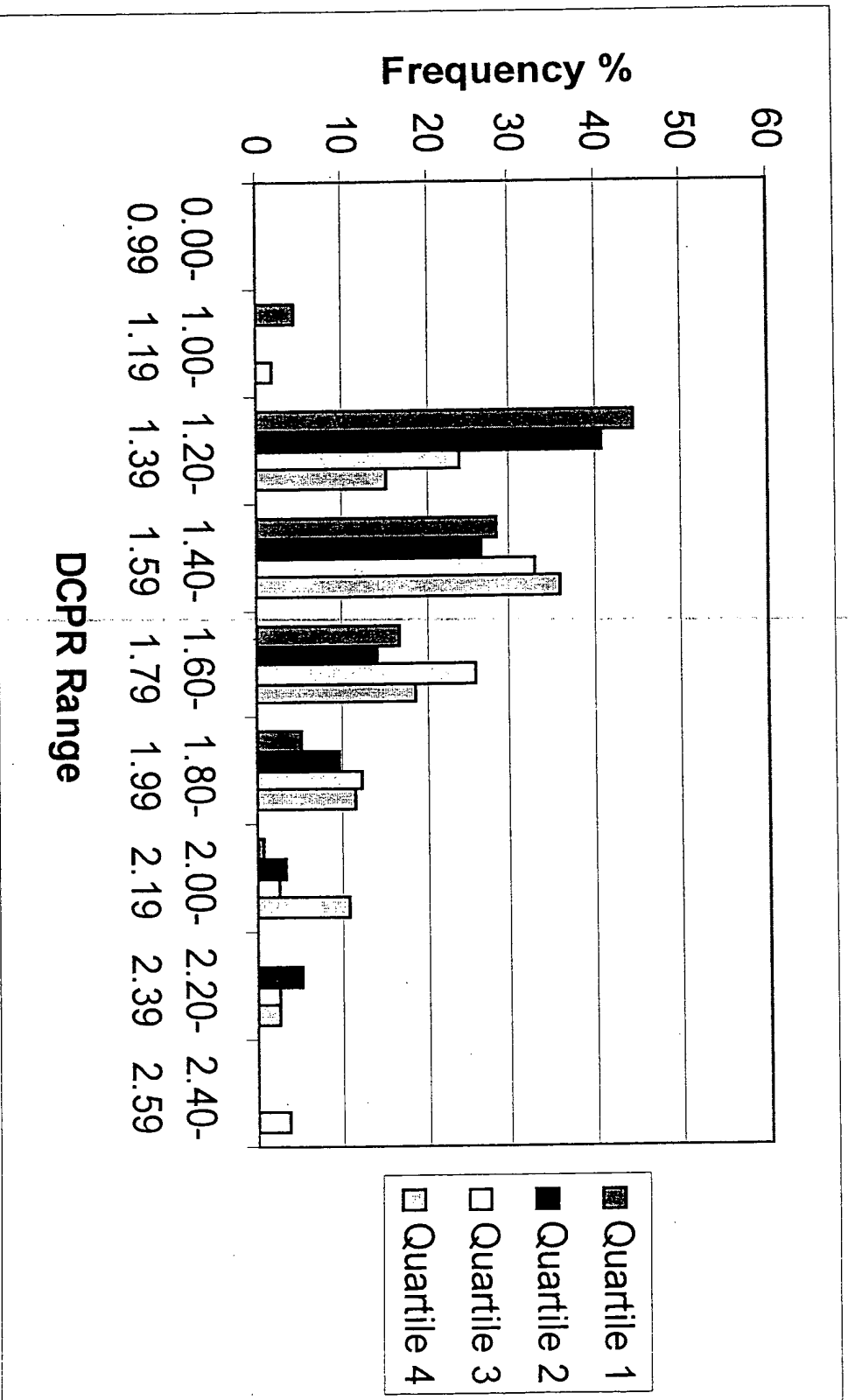




Figure 4

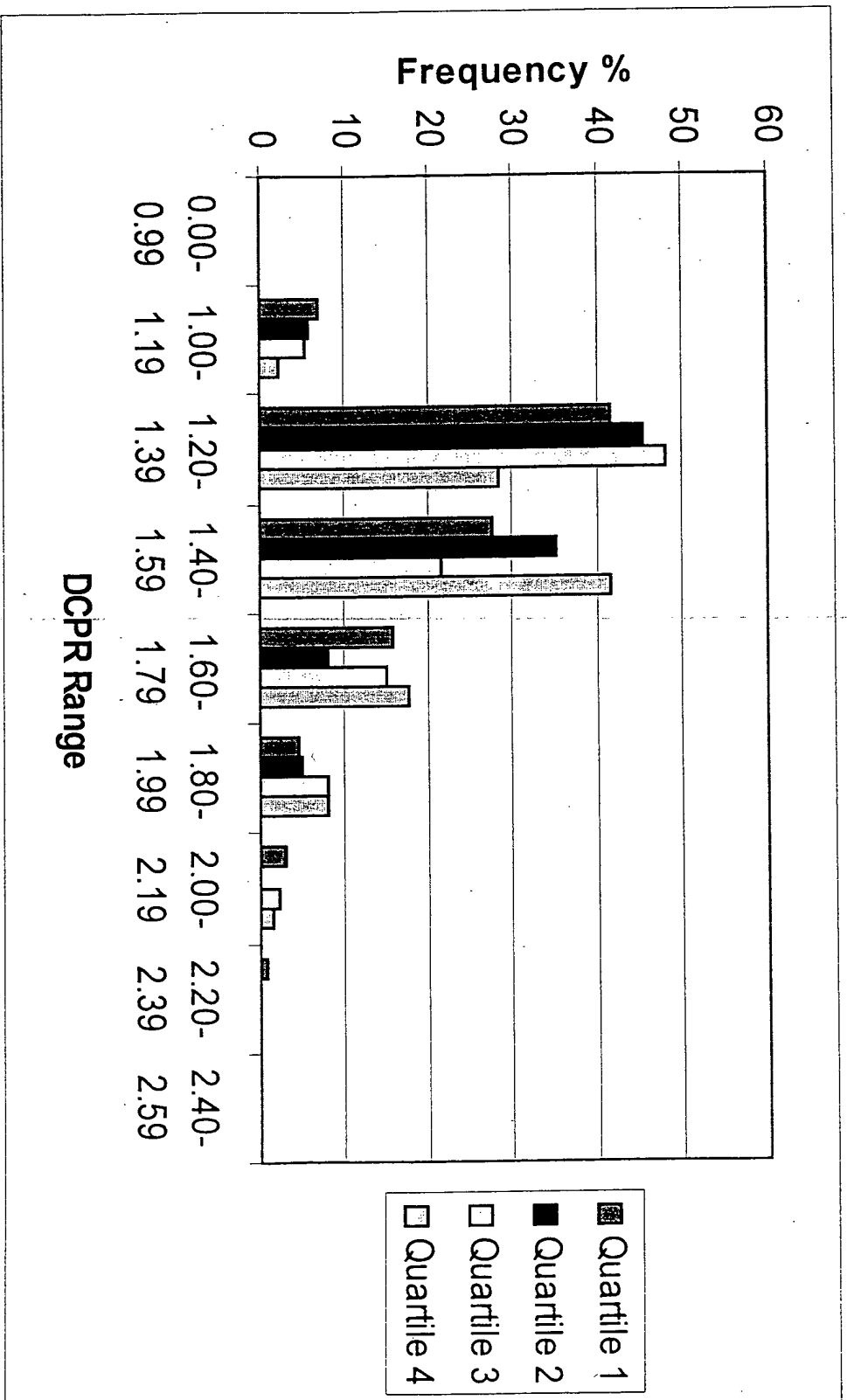




Figure 5

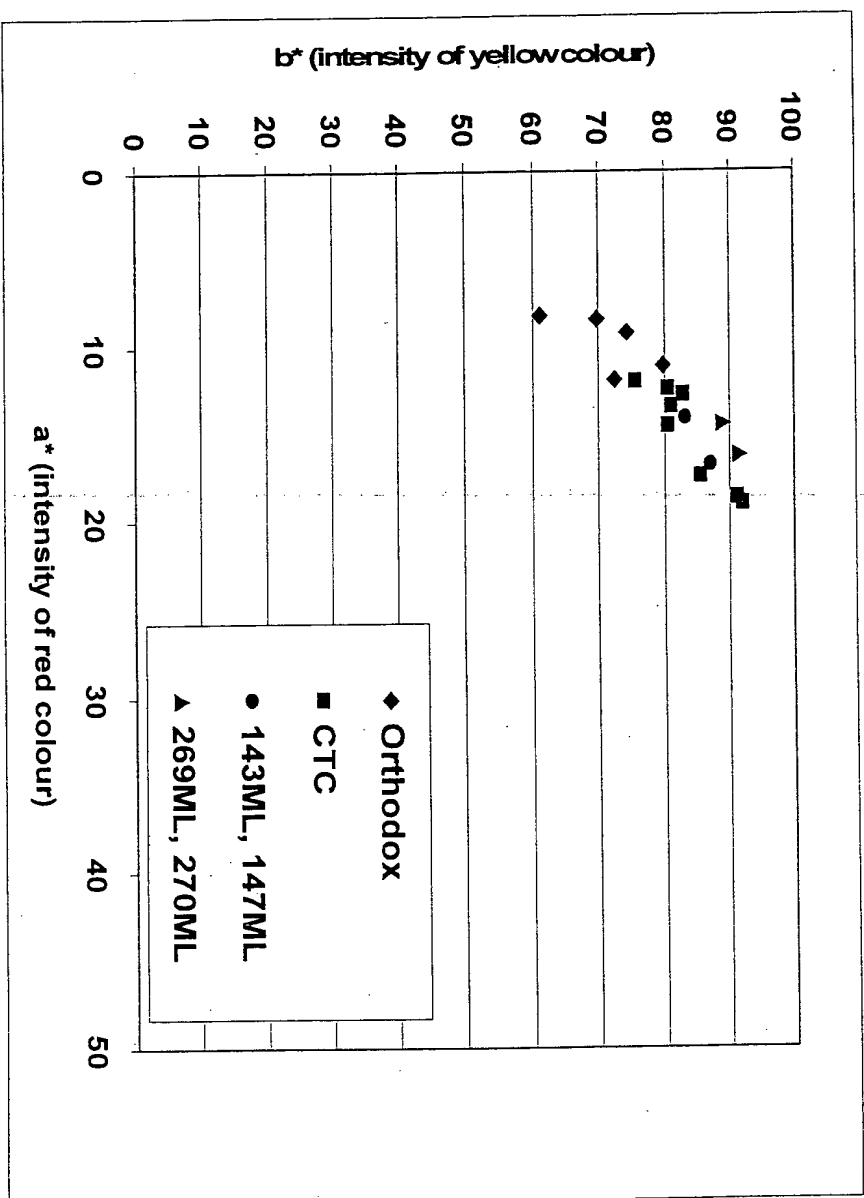




Figure 6

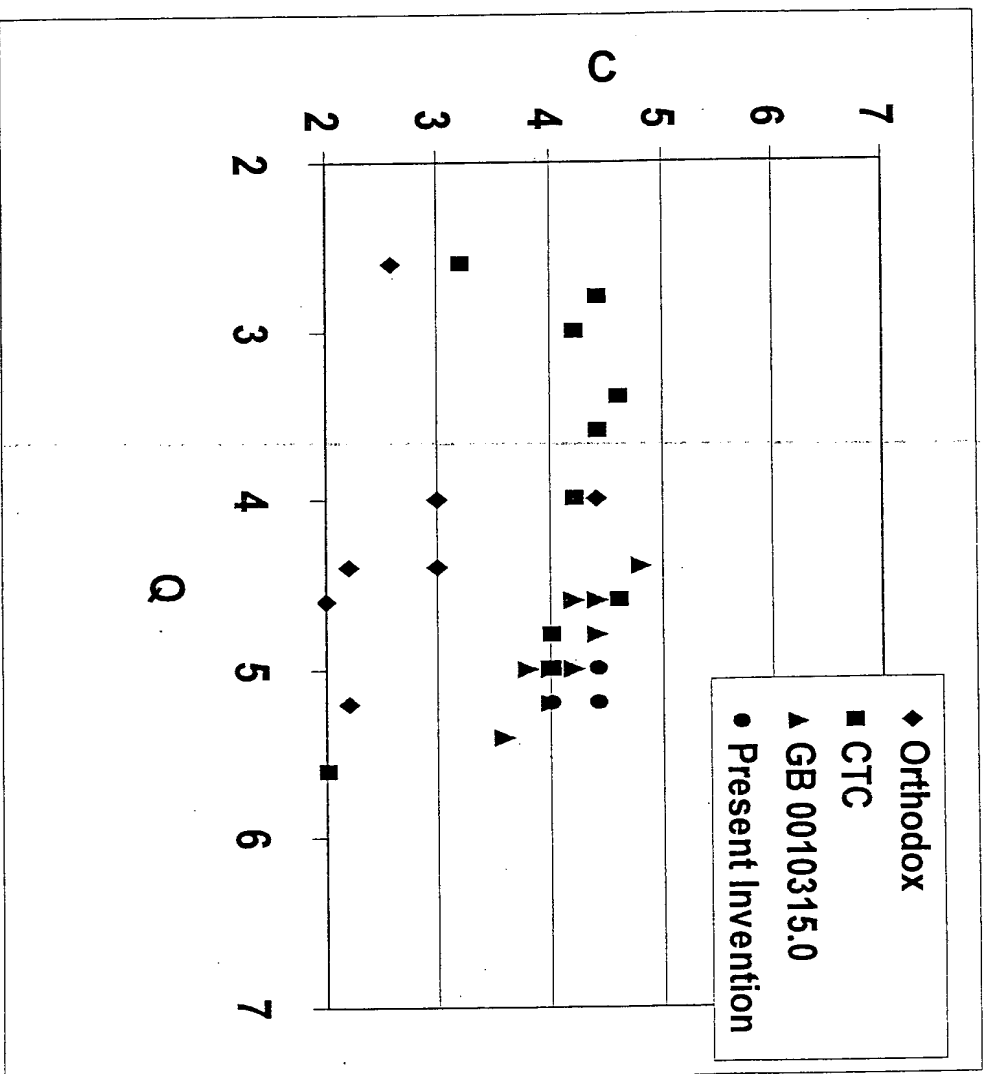




Figure 7

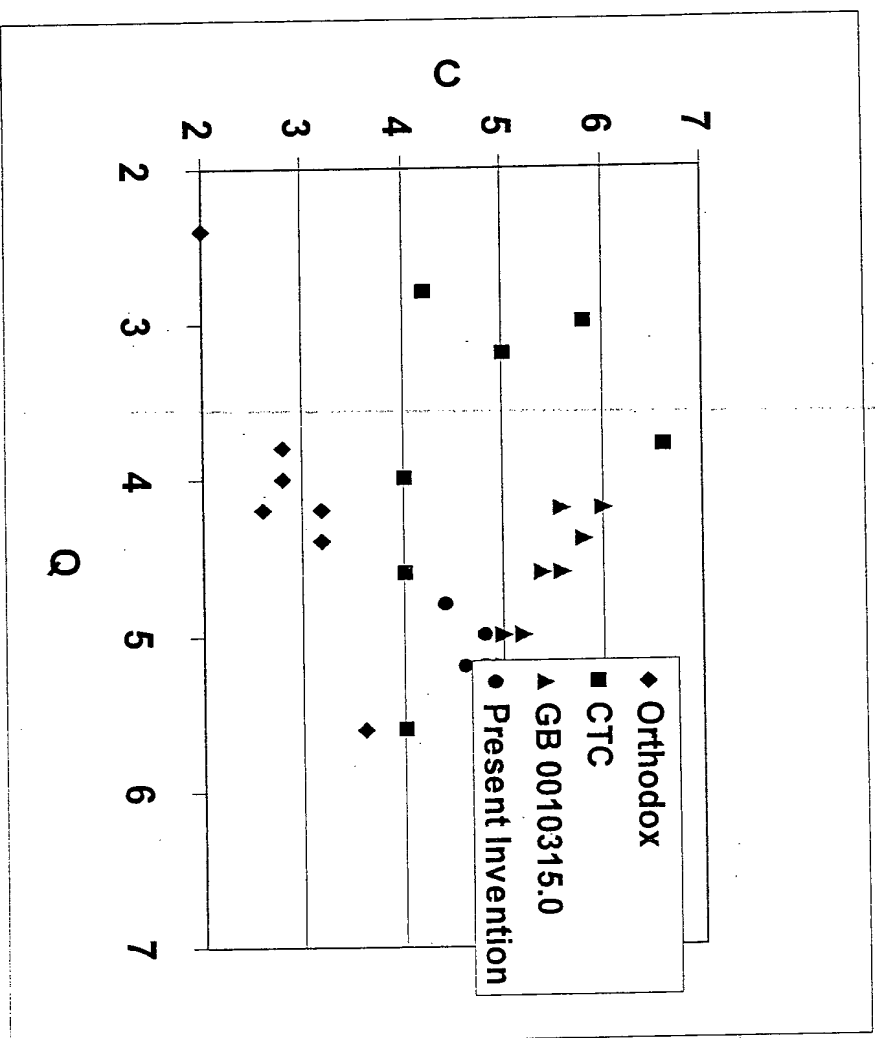




Figure 8

Infusion Performance (unmilked) of long leaved teas made by the method of GB 0010315.0 and by the method of Example 1 (two batches)

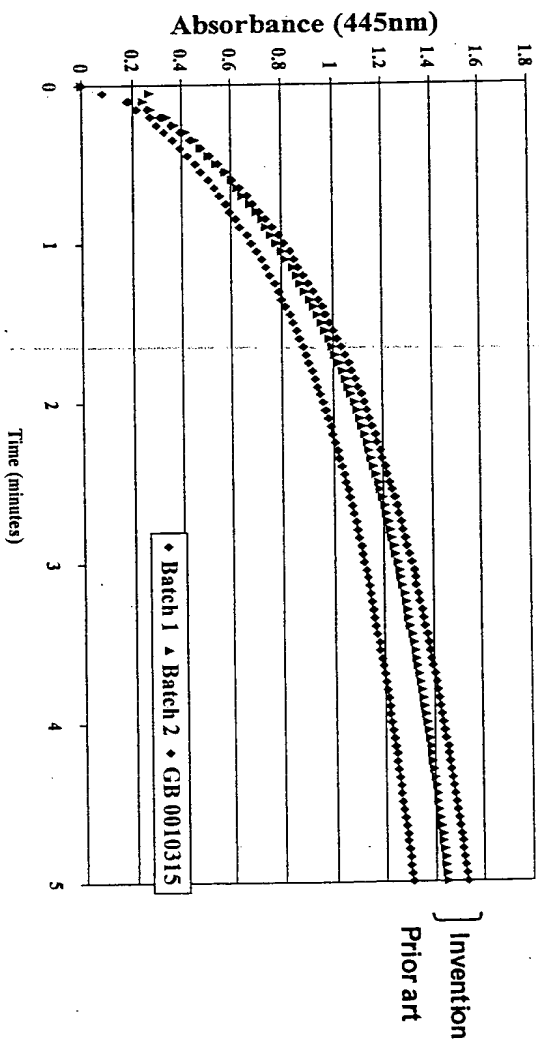




Figure 9

Infusion Performance (unmilked) of medium leaved teas made by the method of GB 0010315.0 and by the method of Example 1 (two batches)

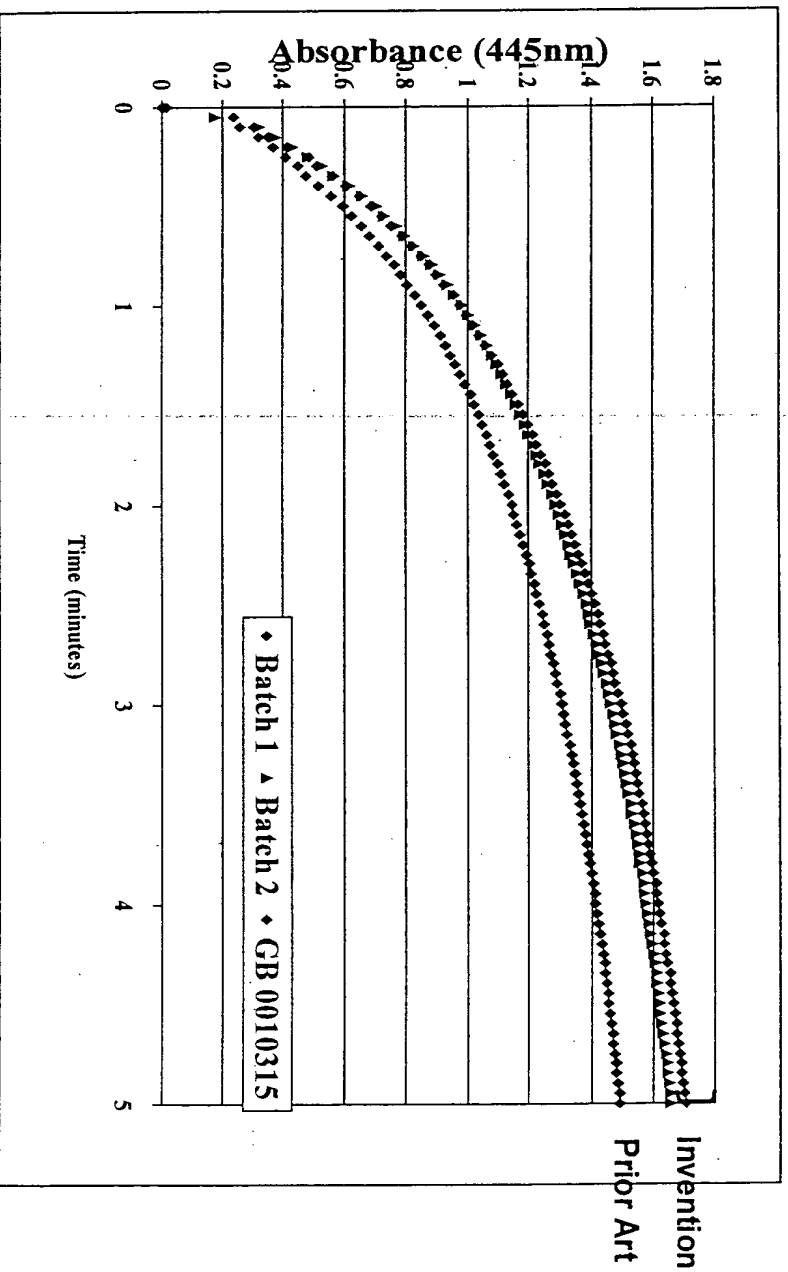




Figure 10

Figure 10. Time course during fermentation of theaflavin levels from tea leaves subjected to a low pressure cut or a combination of a high pressure roll followed by the same low pressure cut.

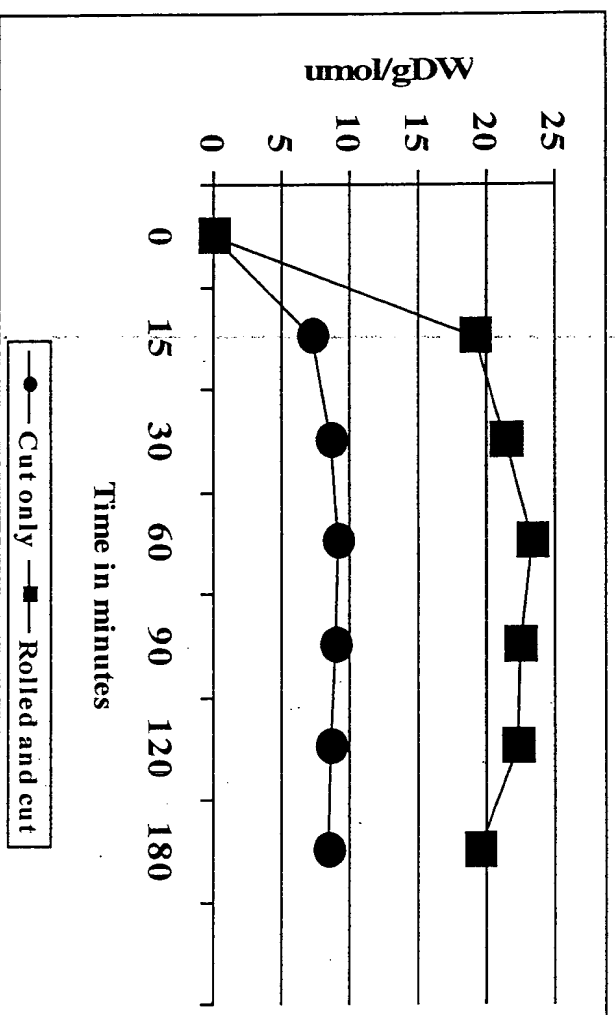




Figure 11

Figure 11. Liquor colours of made teas derived from tea leaves subjected to a low pressure cut or a combination of a high pressure roll followed by the same low pressure roll

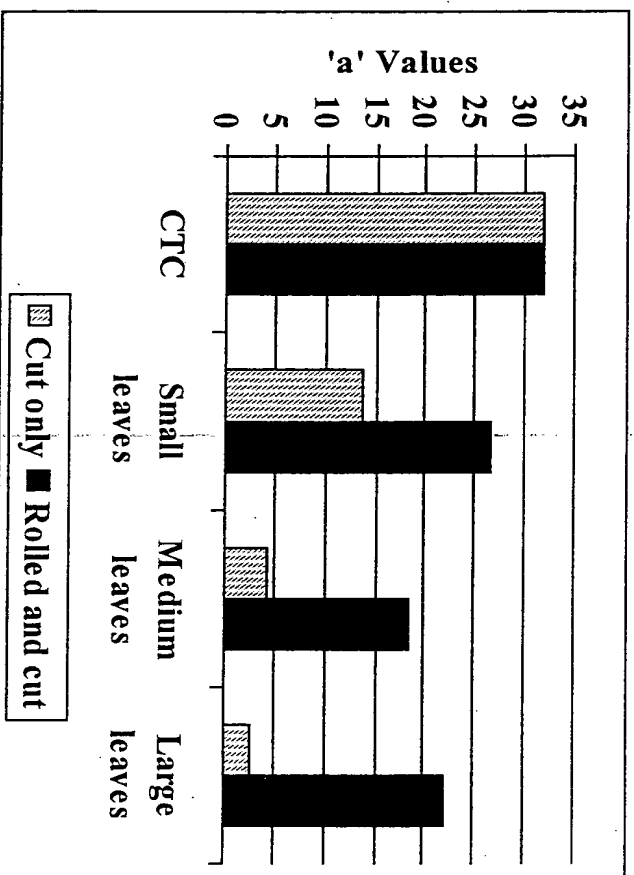
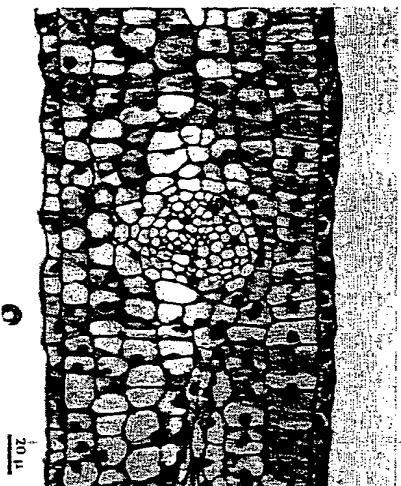




Figure 12

Figure 12. Light microscopy of tea leaves subjected to a low pressure cut (A) or a combination of a high pressure roll followed by the same low pressure cut. (B)

A



B





Figure 13

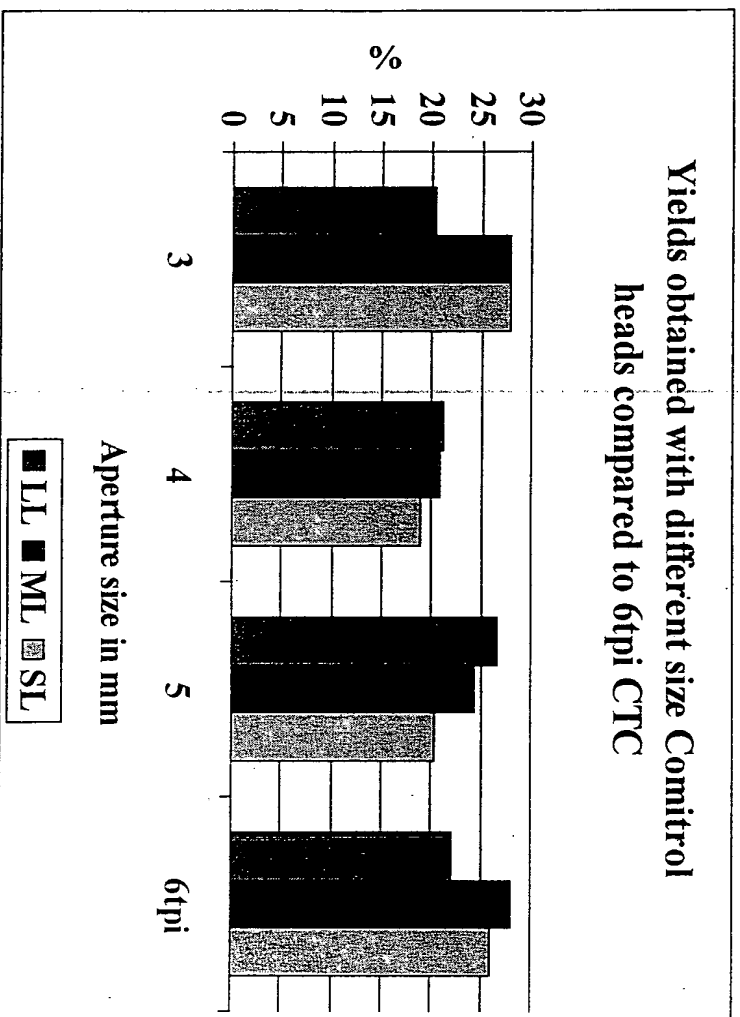




Figure 14

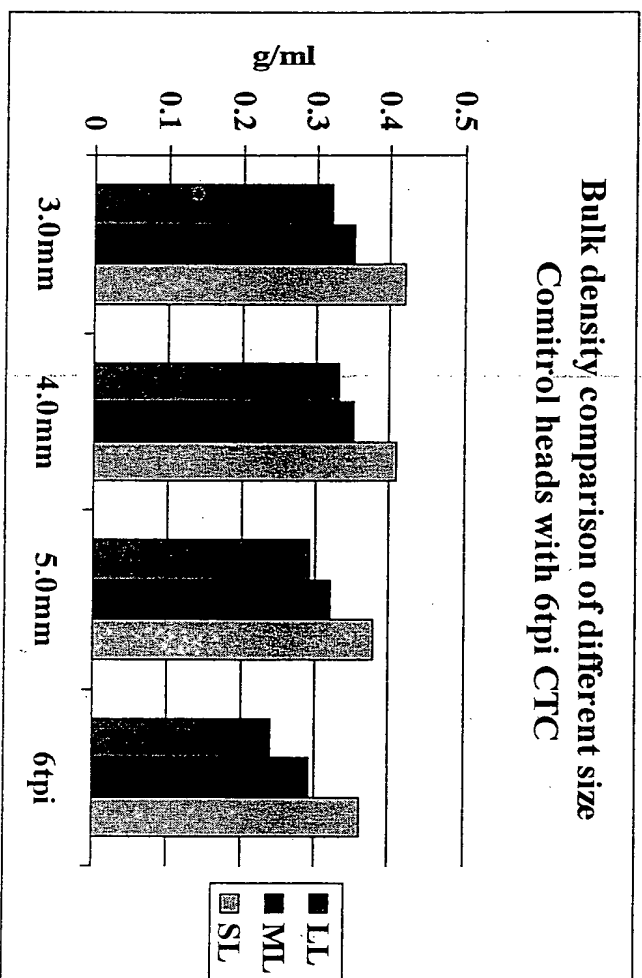




Figure 15

